

6

Work Order ID 160574

Monday, May 01, 2017 4:01:48 PM

160574

Page 1

Item ID: D3913-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Long Basket Base Assembly, 350
Start Date: 6/5/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 6/8/2017 Req'd Qty: 1.00 *1* Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: [Signature] Date: MAY 01 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	C								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 13669S 0.00

100

Large Fab

Large Fab

Large Fab

Memo

3.18

1- assemble ribs , weld as per dwg D3913 using DT9610A
inspect before welding mesh

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.02

1 C 17-06-09

① 17.06.13 15023
D

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss (Ref: 4.3.5.2) per QSI005 4.3-Steel <i>M 137176</i> Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 1ST COAT: START TIME: <i>2:45</i> OVEN TEMPERATURE: <i>375°</i> FINISH TIME: <i>3:00</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.68				<i>1</i>	<i>0</i>	<i>170613</i>	<i>234</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>1</i>	<i>0</i>	<i>1210614</i>	<i>DAS 15 9-89</i>

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Assemble as per dwg Memo Pick Kit DAS 6 9:00 JUN 09 2017	0.00 0.53				1	1	17/06/16	
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1		DAS 38 9:00 JUN 14 2017	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>u6</u> Memo	0.00 0.01				1	1	124030-041 1/13/60372 17/06/16	

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

17/6/19 *[Signature]*

DAS
21
9-89

JUN 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Picklist Print

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Page 1

Work Order ID: 160574

160574

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/5/2017

Required Date: 6/8/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC
AS PER DWG REV.B DD VERF:EC
REV.C / ECN 13-624 DD VERF:JLM
IPP Rev:B
IPP REV:C 12.07.24
IPP REV:D 13.08.21 DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3913-1

Manufactured

No

100

Each

3.0000

1

1

D3913-1

Rib

B157756 → 1.00 Cg 17-06-08

Location

Loc Qty

Loc Code

WA004

3

157756

3

D3913-3

Manufactured

No

100

Each

3.0000

1

1

D3913-3

Rib

B161329 → 1.00 Cg 17-06-08

Location

Loc Qty

Loc Code

WA004

3

146448

1

157564

2

D3913-7

Manufactured

No

100

Each

4.0000

2

2

D3913-7

Rib

B161982 → 2.00 Cg 17-06-08

Location

Loc Qty

Loc Code

WA004

4

156428

4

D3913-9

Manufactured

No

100

Each

3.0000

1

1

D3913-9

Hinge Rib

B157483 → 1.00 Cg 17-06-08

Location

Loc Qty

Loc Code

WA004

3

155678

3

DQA: _____ Date: _____



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Work Order ID: 160574

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/5/2017

Required Date: 6/8/2017

Start Qty: 1.00

Required Qty: 1.00

D3916-5 Manufactured No

100 Each

8.0000

3 3

✓ ***D3916-5***

Light Rib

** 3x Cg 17-06-08

B161510 → 2x

B161960 → 1x

Location

Loc Qty

Loc Code

WA004

8

157561

8

D3916-041 Manufactured No

100 Each

6.0000

2 2

✓ ***D3916-041***

Rib Assembly

** B1620417 → 2x Cg 17-06-08

Location

Loc Qty

Loc Code

WA004

6

157746

6

D4017-7 Manufactured No

100 Each

7.0000

3 3

✓ ***D4017-7***

Rib

** 3x → 3x Cg 17-06-08

B161935 → 1x

B160510 → 2x

Location

Loc Qty

Loc Code

WA004

7

158860

7

D4017-9 Manufactured No

100 Each

6.0000

2 2

✓ ***D4017-9***

Rib

** B161509 → 2x Cg 17-06-08

Location

Loc Qty

Loc Code

WA004

6

157621

6

D4034-041 Manufactured No

100 Each

4.0000

1 1

✓ ***D4034-041***

Aft Upper Rib Assembly

** B160516 → 1x Cg 17-06-08

Location

Loc Qty

Loc Code

WA004

4

157479

4

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER :																																																															

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Work Order ID: 160574

160574

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/5/2017

Required Date: 6/8/2017

Start Qty: 1.00

Required Qty: 1.00

D4034-043

Manufactured No

100

Each

4.0000

1

1

D4034-043

Fwd Upper Rib Assembly

**

B161421 → 1x 17-06-08

Location

Loc Qty

Loc Code

WA004

4

153910

1

157739

3

D2581

Manufactured No

100

Each

72.0000

2

2

D2581

Mounting Bracket

**

B161800 2x 17-06-08

Location

Loc Qty

Loc Code

WA004

72

152803

32

157620

24

159116

16

D2931

Manufactured No

150

Each

1,360.000

2

2

D2931

Bumper

**

DAS 9-89 JUN 09 2017

Location

Loc Qty

Loc Code

ST013

60

86435

60

ST025A

1300

86435

1300

D3913-15

Manufactured No

100

Each

17.0000

1

1

D3913-15

Wide Handle Plate

**

B161938 → 1x 17-06-08

Location

Loc Qty

Loc Code

WA004

17

157671

17

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Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

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Page 4

Work Order ID: 160574

160574

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/5/2017

Required Date: 6/8/2017

Start Qty: 1.00

Required Qty: 1.00

D4016-1 Manufactured No

100 Each 60.0000 3 3

D4016-1

Hinge Half, Base

** 3x 17-06-08

Location	Loc Qty	Loc Code
WA004	60	
154145	14	
155346	6	
158630	40	

B158630 → 1x
B159537 → 2x

D4021-1 Manufactured No

100 Each 41.0000 3 3

D4021-1

Handle Plate

** B161473 → 3x 17-06-08

Location	Loc Qty	Loc Code
WA004	41	
157523	30	
159375	11	

1

D4021-5 Manufactured No

100 Each 15.0000 2 2

D4021-5

Blanking Plate

** DAS
6
9-89

Location	Loc Qty	Loc Code
ST071	15	
156433	6	
157458	9	

161816

D4020-11 Manufactured No

100 Each 19.0000 2 2

D4020-11

End Mesh, Basket

** B161475 → 2x 17-06-08

Location	Loc Qty	Loc Code
WA004	19	
154521	1	
156918	10	
157499	8	

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID: 160574

160574

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/5/2017

Required Date: 6/8/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D4672-1
D4672-1
Blanking Plate

Manufactured No

100 Each

24.0000

2 2

**** B157497 → 2. Cg 17-06-08**

Location

Loc Qty

Loc Code

WA004

24

153098

7

157497

17

✓ M304EX0.75-16F
M304EX0 75-16F
Expanded Metal Flat SS

Purchased No

100 sf

301.5000

33 33

**** 33x Cg 17-06-08**
B137491 →

Location

Loc Qty

Loc Code

WA004

301.5

M136991

30.5

M137294

271

MS20600-AD4W3

Purchased No

150 Each

208.0000

2 2

MS20600-AD4W3
Cherry Rivet

**** B sl**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST308

148

m135603

148

WA003

60

m136648

60

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Work Order ID: 160574

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

160574

D3913-041

Start Date: 6/5/2017

Required Date: 6/8/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,548.000

6

6

DAS

MS21042L3

6

Nut

9-89

Location

Loc Qty

Loc Code

FP001

91

m135945

91

GA

464

m134360

102

M136665

362

137495

ST303

993

m137073

11

m137166

3

m137321

979

DAS

6

9-89

NAS1149F0332P

Purchased

No

150

Each

1,265.000

12

12

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

990

137412

m137075

990

AN3-10A

Purchased

No

150

Each

223.0000

6

6

AN3-10A

DAS

6

9-89

Bolt

Location

Loc Qty

Loc Code

GA

60

m136787

60

ST349

163

m137321

163

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID: 160574

160574

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/5/2017

Required Date: 6/8/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

150

Each

740.0000

2

2

NAS1149DN832.J

DAS

6

Washer

~~9-89~~

Location

Loc Qty

Loc Code

ST264

740

M135297

740

2

DQA: _____ Date: _____



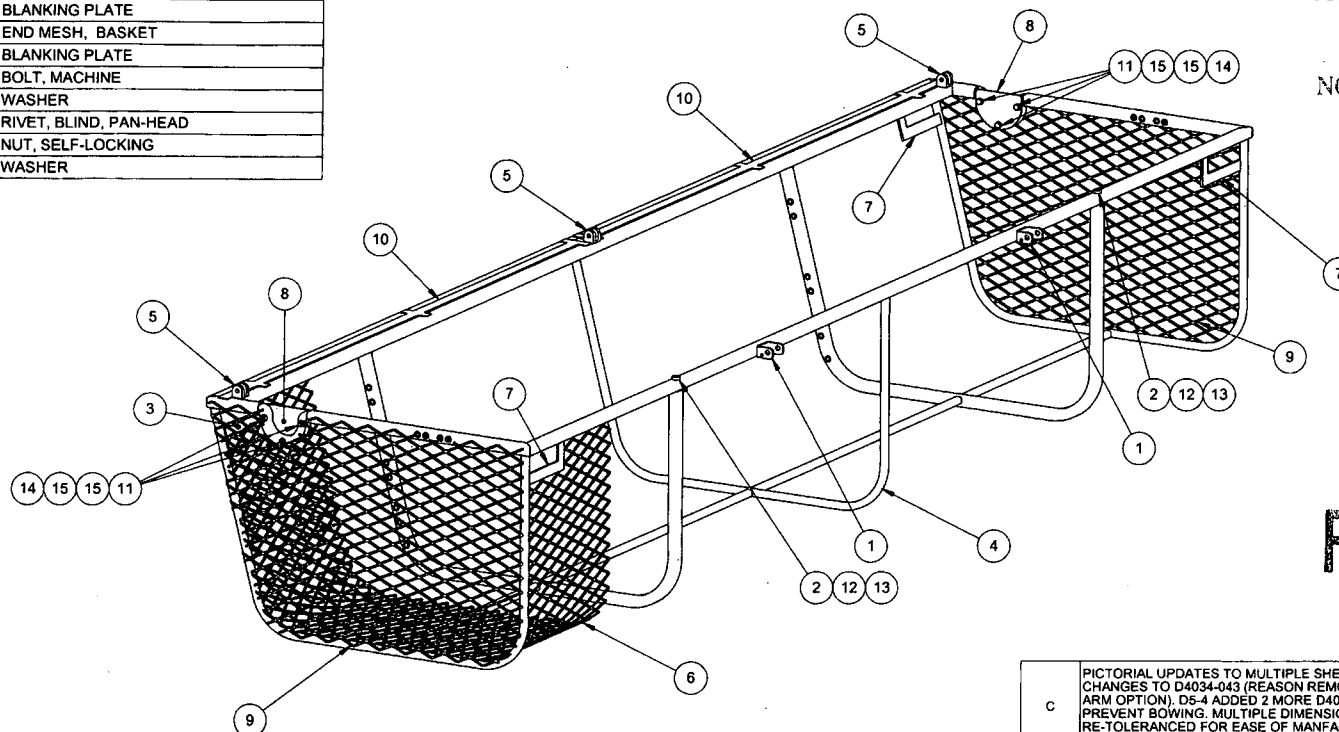
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	3	D4021-1	HANDLE PLATE
8	2	D4021-5	BLANKING PLATE
9	2	D4020-11	END MESH, BASKET
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT, MACHINE
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET, BLIND, PAN-HEAD
14	6	MS21042L3	NUT, SELF-LOCKING
15	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

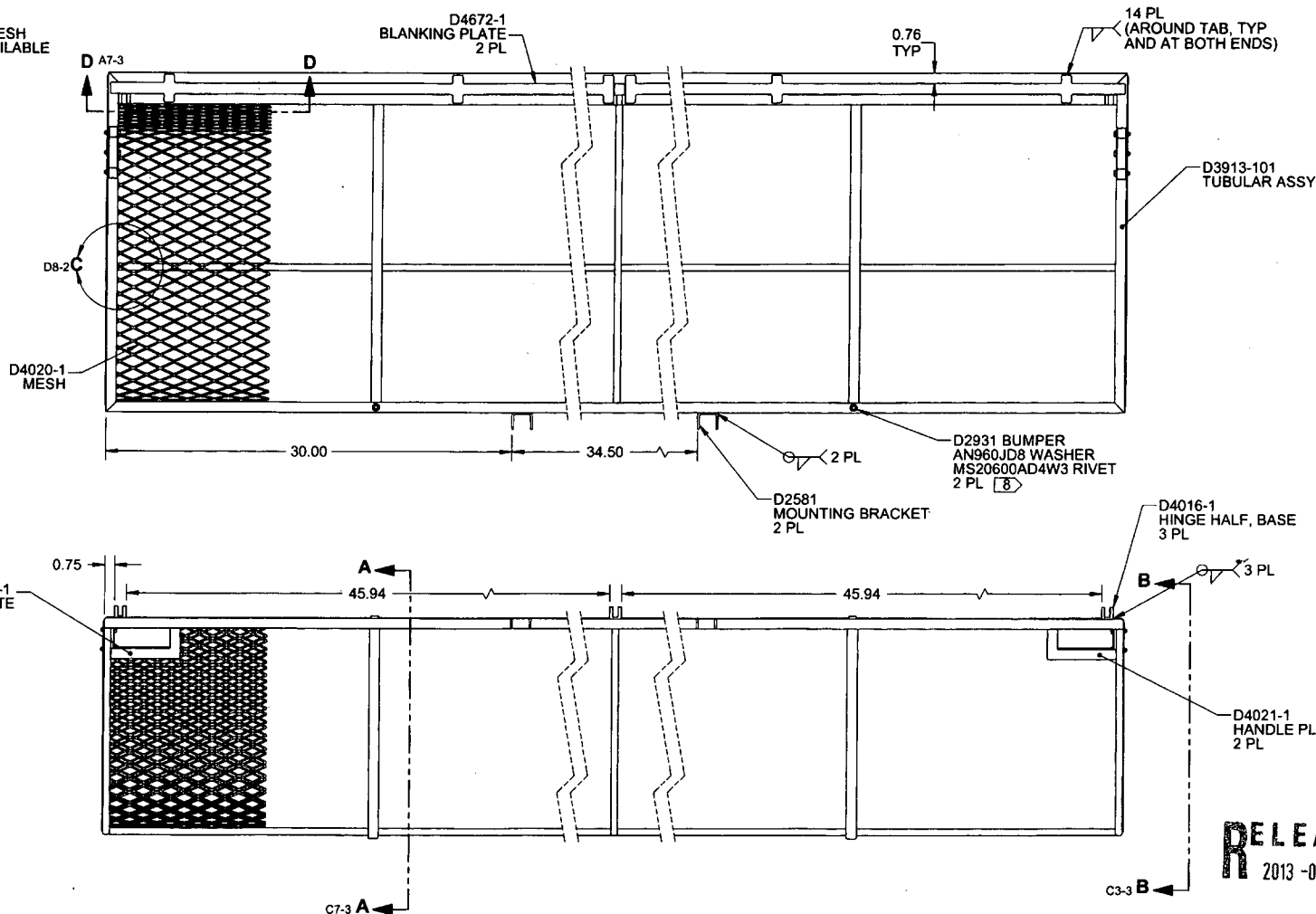
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160574
MAY 01 2017

RELEASED
2013-08-16

C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 TITLE LONG BASKET BASE ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.07.18		

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

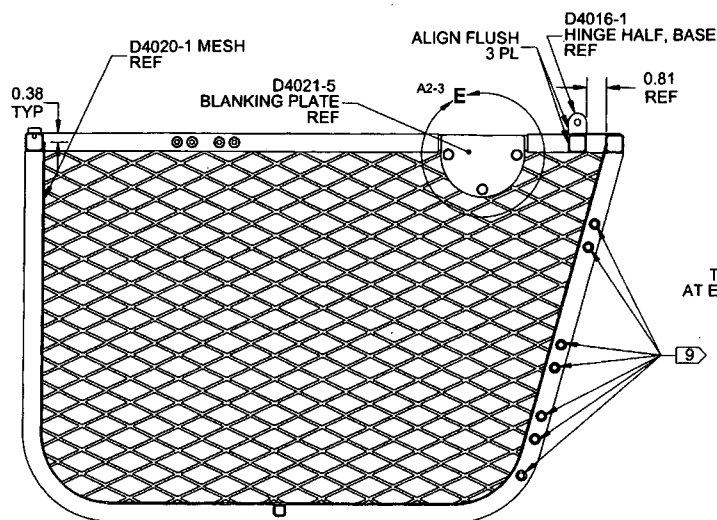
DETAIL C D7-2
SCALE: 2X



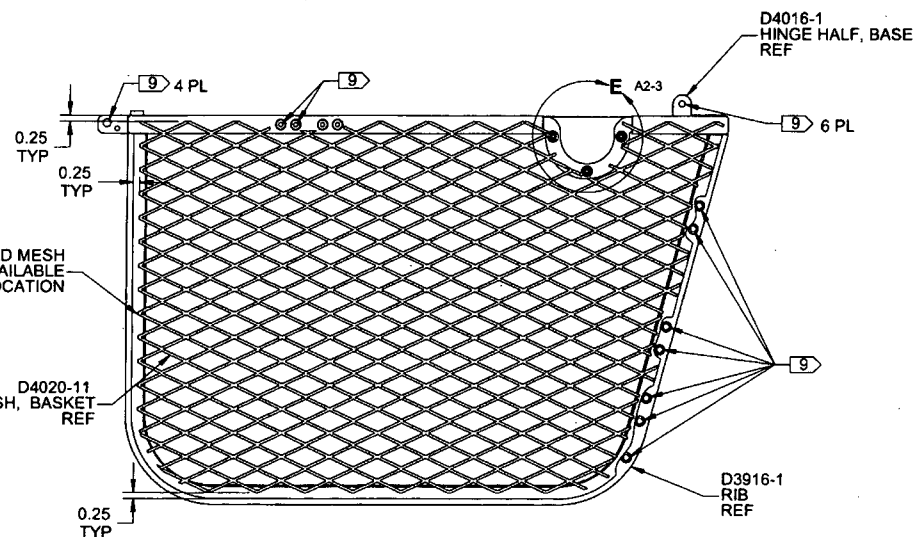
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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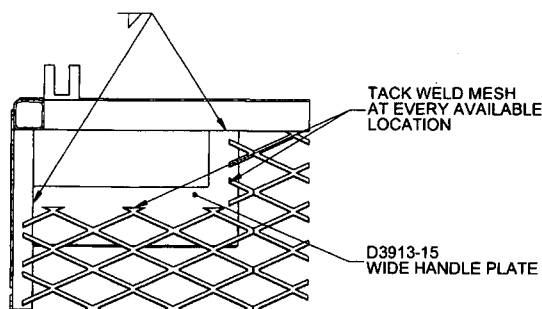
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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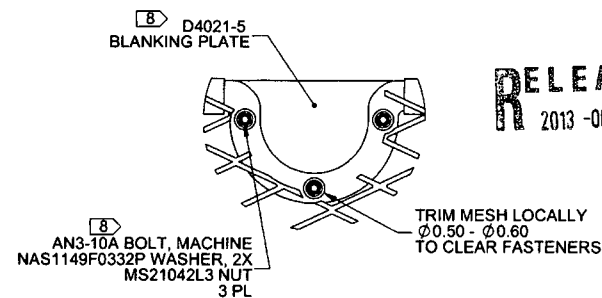
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES

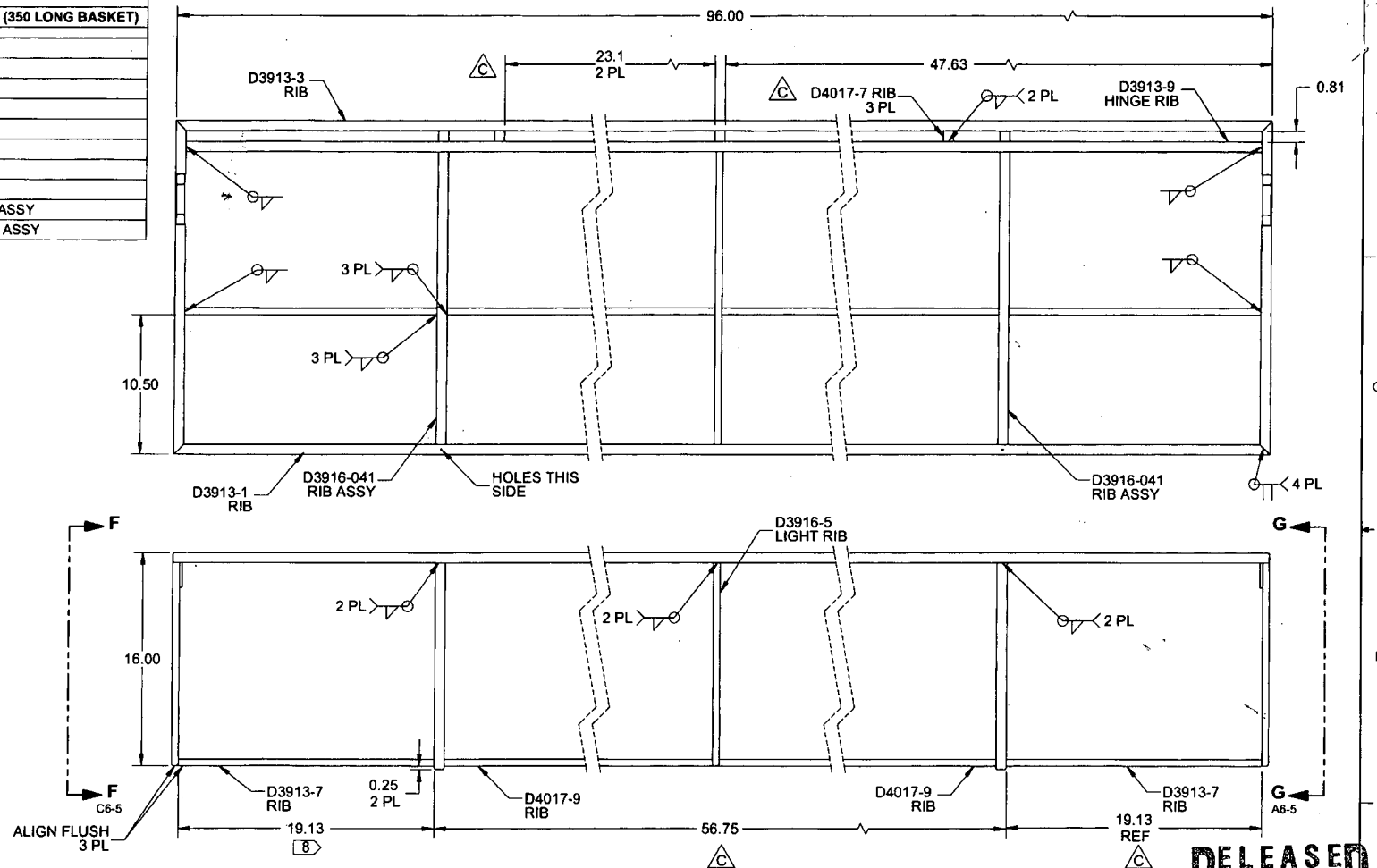


DETAIL E D2-3
D6-3

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2013-08-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	3	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

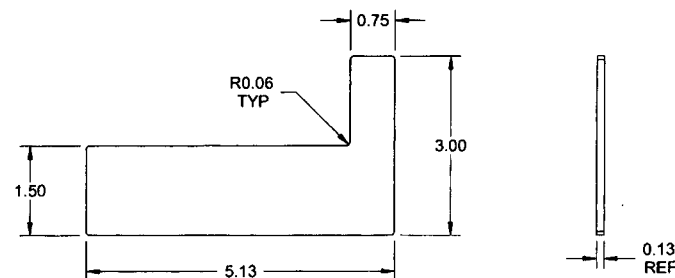
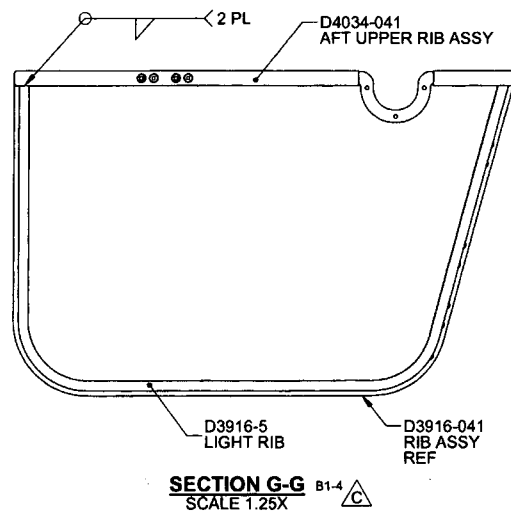
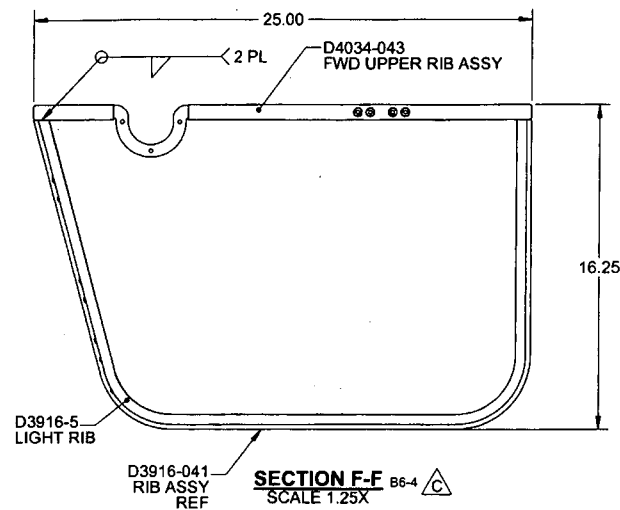


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.65 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

D3913-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>[Signature]</i>		
DATE:	13.07.18		

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2013-08-16



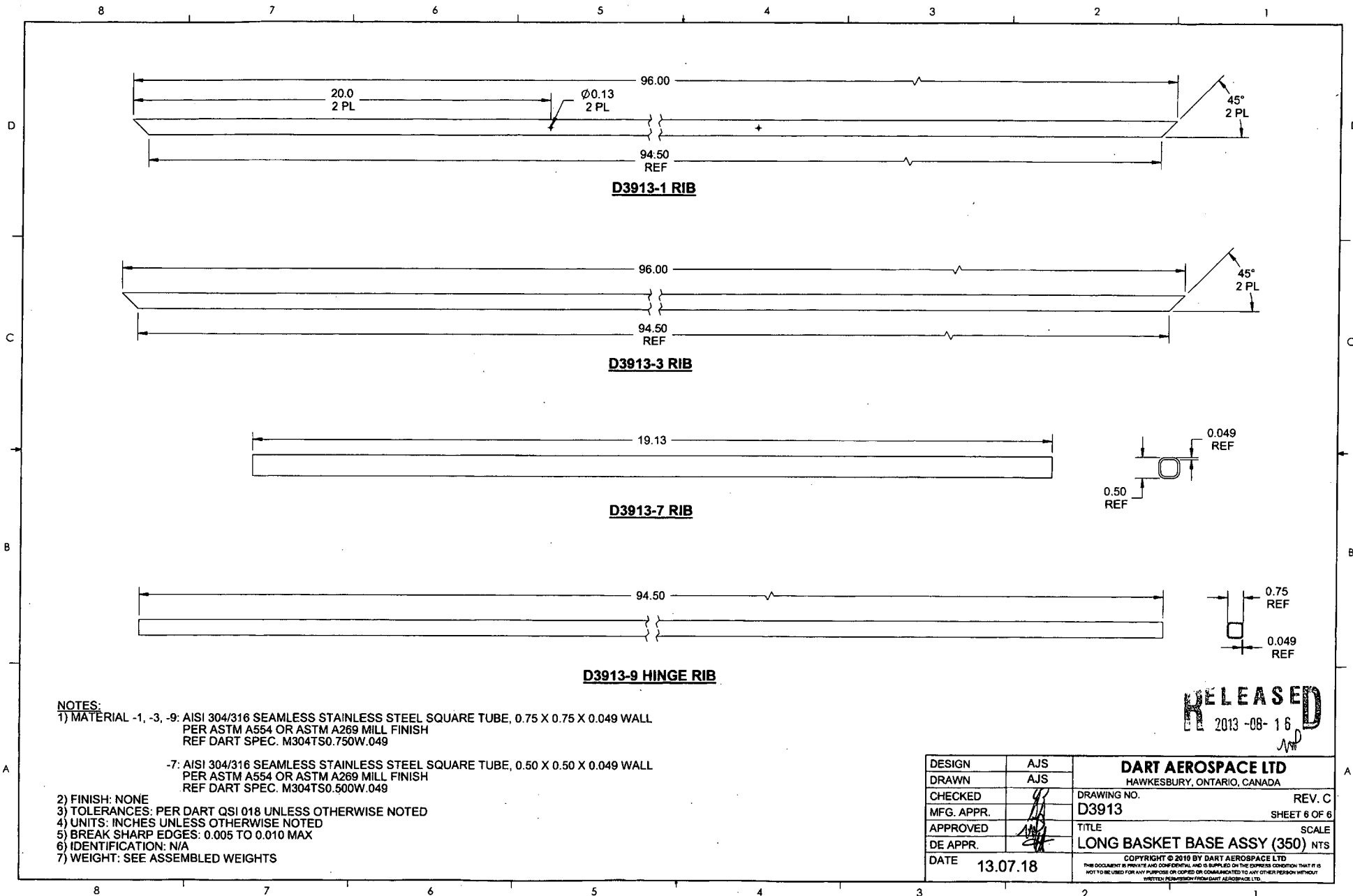
D3913-15 WIDE HANDLE PLATE

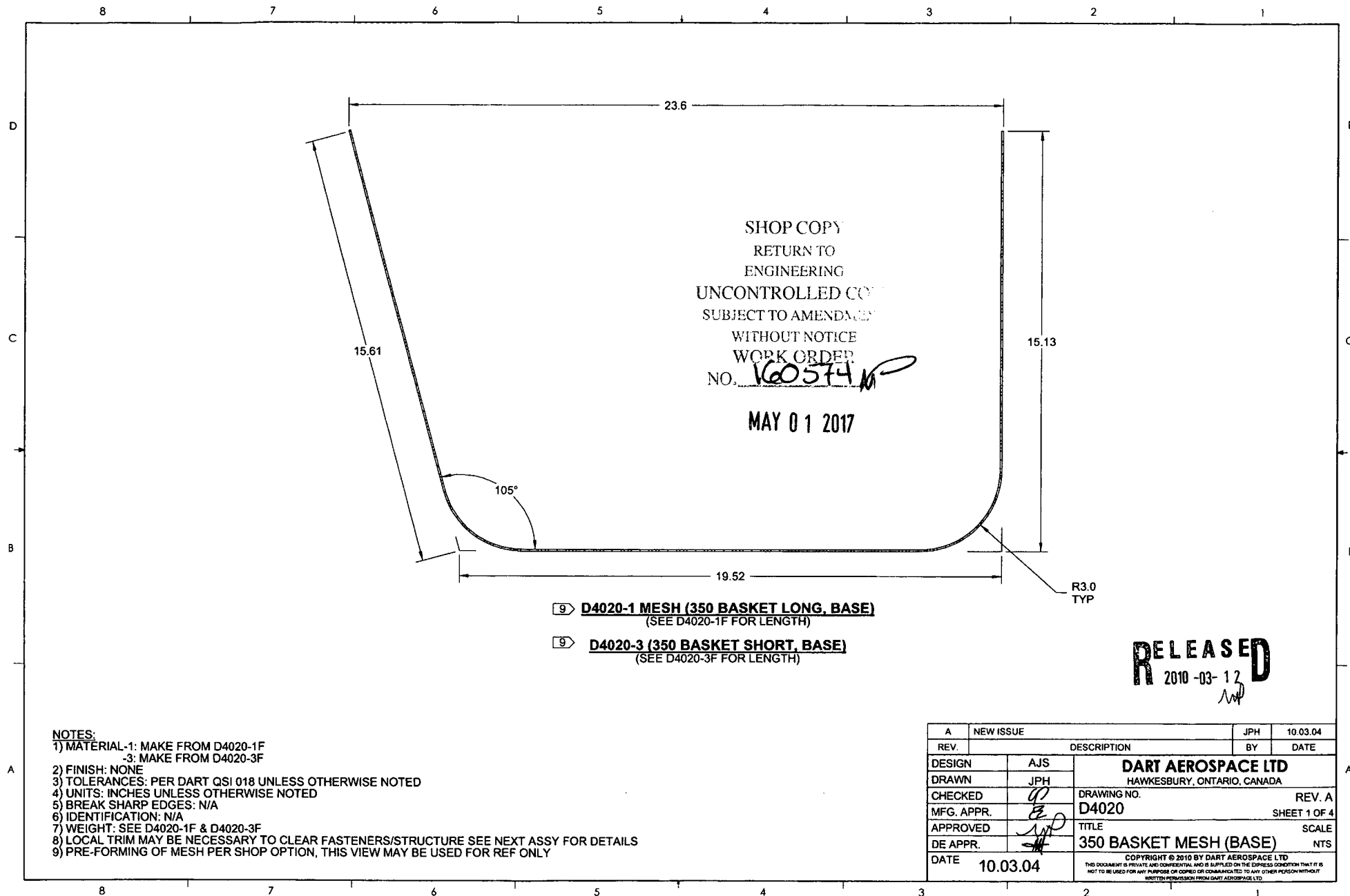
NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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2013-08-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 5 OF 6
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350) NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 160574

MAY 01 2017

- 9 D4020-1 MESH (350 BASKET LONG, BASE)
 (SEE D4020-1F FOR LENGTH)
- 9 D4020-3 (350 BASKET SHORT, BASE)
 (SEE D4020-3F FOR LENGTH)

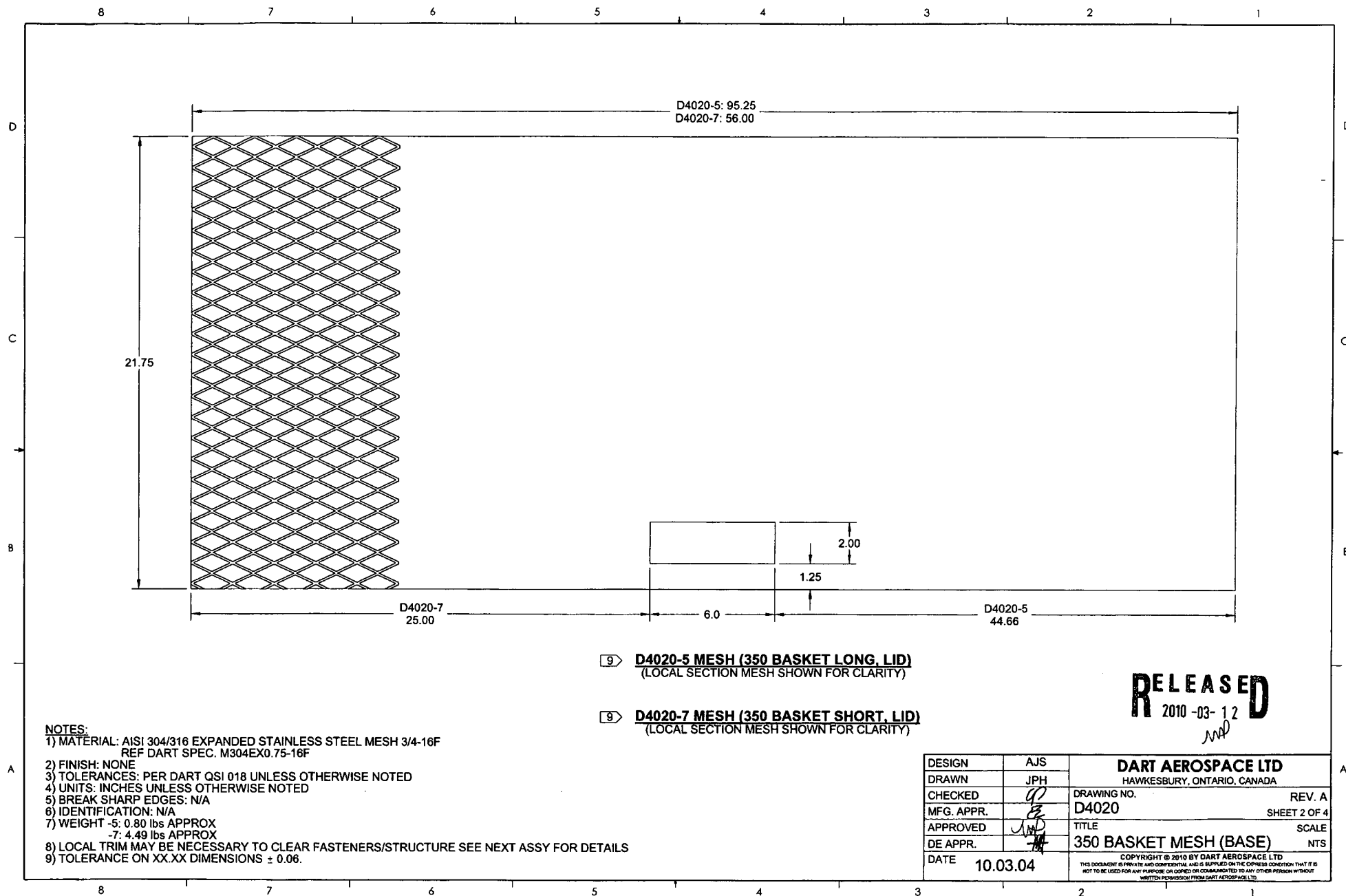
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 2010-03-12

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
 -3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	E	D4020	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



9) **D4020-5 MESH (350 BASKET LONG, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

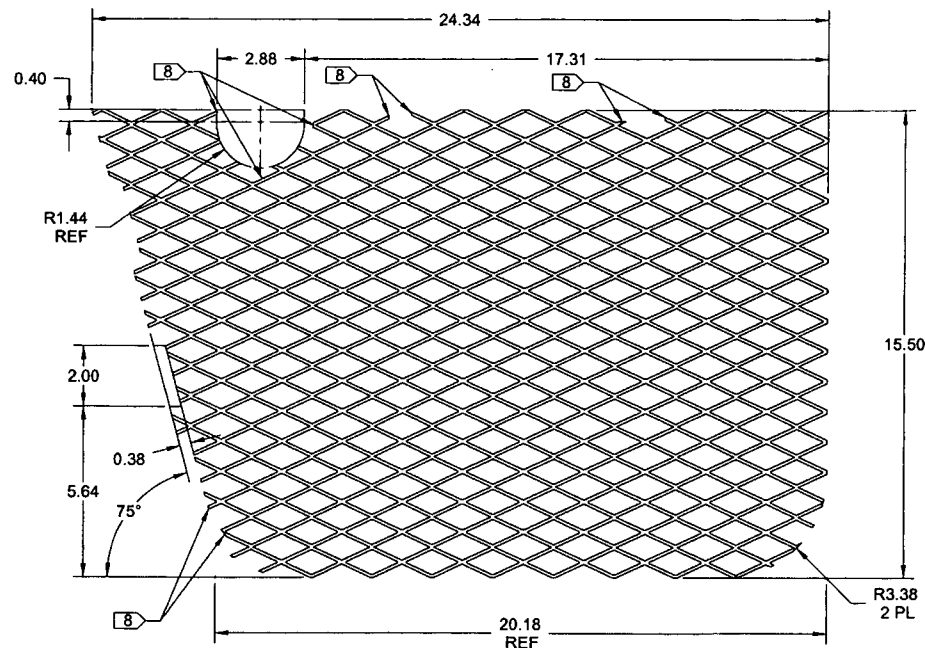
9) **D4020-7 MESH (350 BASKET SHORT, LID)**
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
WJ

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	W	DRAWING NO. D4020	REV. A SHEET 2 OF 4
MFG. APPR.	E	TITLE 350 BASKET MESH (BASE)	SCALE NTS
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DE APPR.	WJ		
DATE	10.03.04		



9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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2010-03-12

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO. D4020	REV. A
MFG. APPR.	JP	SHEET 3 OF 4	
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	
DATE	10.03.04	NTS	

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